

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																									

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 154153***154153***

Page 3

Tuesday, December 06, 2016 1:15:35 PM

Item ID: D2893-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 11/22/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/6/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.17

Quality Control

DAS
21
9-89

JAN 10 2017

mf
17-1-10

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OTHER : ☐																									

Picklist Print

Tuesday, December 06, 2016 1:15:34 PM

Page 1
1

Work Order ID: 154153

154153

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 11/22/2016

Required Date: 12/6/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C02.11.26Reformat; Added P/OKJ
IPP D 06.04.19 removed alodine EC
IPP Rev:E Added priming as per Rev B 07-04-30 JLM
IPP F 08.03.19 Re-format EC verified by: DD
IPP Rev:G 08-05-15 add QC14 DD verified by:EC
11.08.04 as per dwg rev.C DD verf:EC
IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK078

Manufactured No

100

Each

11.0000

0.5

5

DSK078

D2893-1 Turning Detail

D.A 16-12-18

Location

Loc Qty

Loc Code

MAT060

11

151098

5

153126

6

4.0

4.0

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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OTHER : ☐					

DART AEROSPACE LTD		Work Order: 154153
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.993	2.993	2.995	2.995
AB	0.440	0.460		0.455	0.455	0.455	0.455	0.455
AC	0.125	0.160		0.127	0.127	0.127	0.127	0.127
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AF	0.125	0.160		0.135	0.135	0.135	0.135	0.135
AG	0.140	0.160		0.147	0.146	0.147	0.148	0.147
AH	1.360	1.400		1.377	1.383	1.381	1.378	1.381
AI	0.040	0.060		0.049	0.047	0.051	0.053	0.050
AJ	1.190	1.230		1.215	1.221	1.221	1.221	1.218
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.536	2.536	2.536	2.538	2.536
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.262	0.262	0.262	0.262	0.262
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: DAS 08 9-39	Date: 16-12-18
Audited by: DAS 33 9-89	Date: 17/01/04
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 154153
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	2.985	3.005		2.992	2.992	2.997	3.001	3.003
AB	0.440	0.460		0.455	0.455	0.455	.450	.453
AC	0.125	0.160		0.127	0.127	0.127	.127	.127
AD	0.040	0.060		0.050	0.050	0.050	.050	.050
AE	0.188	0.193		0.189	0.189	0.189	.189	.189
AF	0.125	0.160		0.135	0.135	0.135	.136	.136
AG	0.140	0.160		0.147	0.147	0.148	.147	.149
AH	1.360	1.400		1.379	1.378	1.383	1.381	1.381
AI	0.040	0.060		0.049	0.049	0.049	.049	.049
AJ	1.190	1.230		1.219	1.216	1.220	1.221	1.216
AK	0.010	0.020		0.010	0.010	0.010	.010	.010
AL	0.053	0.073		0.063	0.063	0.063	.063	.063
AM	0.240	0.260		0.250	0.250	0.250	.250	.250
AN	2.518	2.538		2.536	2.536	2.536	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.262	0.262	0.262	.262	.262
AQ	0.053	0.073		0.063	0.063	0.063	.063	.063
AR								
AS								
AT								
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Measured by: H.E.	DAS 08 9-08	DAS 14 9-09	Date: 16-12-19
Audited by:	DAS 33 9-89		Date: 17/01/04
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Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.995	2.997	3.000	3.000	2.990
AB	0.440	0.460		.453	.453	.450	.452	.455
AC	0.125	0.160		.128	.128	.128	.128	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.136	.136	.136	.136	.136
AG	0.140	0.160		.148	.147	.147	.147	.145
AH	1.360	1.400		1.373	1.376	1.375	1.374	1.375
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.211	1.216	1.214	1.212	1.212
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.532
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: DAS 14 9-89	Date: 16/12/20
Audited by: DAS 33 9-89	Date: 17/01/21
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 159153
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

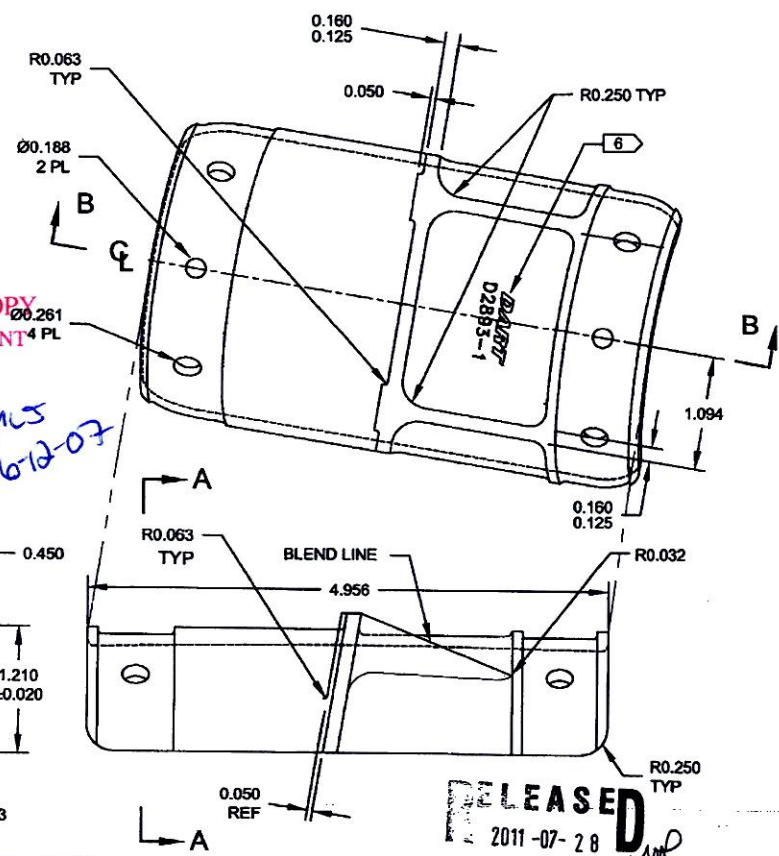
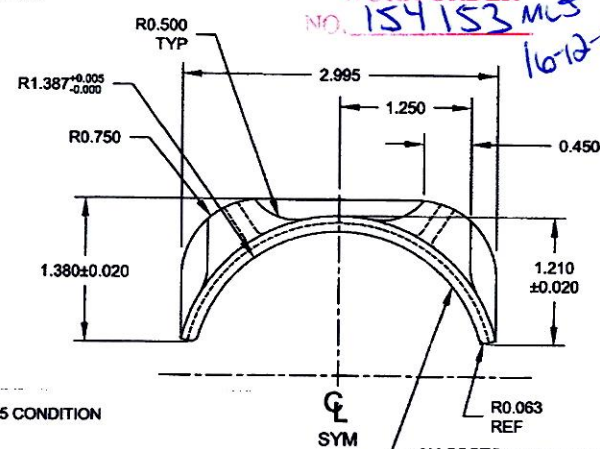
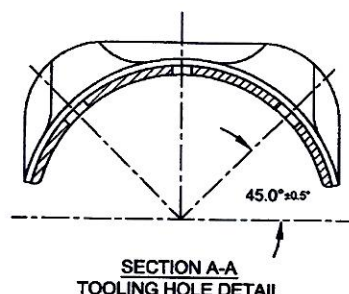
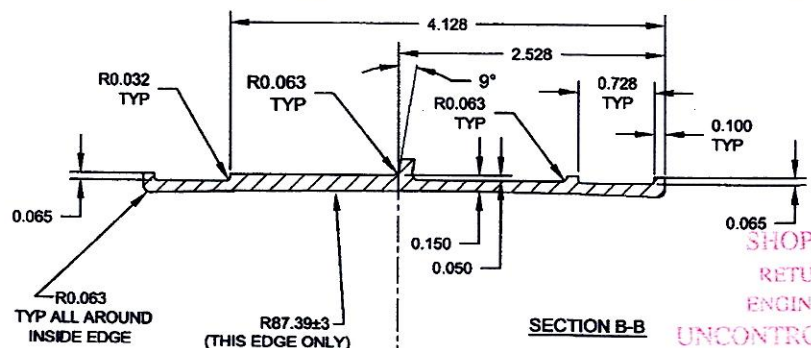
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	#1	#2	#3	#4
HAAS Section								
AA	2.985	3.005		2.990				
AB	0.440	0.460		.455				
AC	0.125	0.160		.130				
AD	0.040	0.060		.050				
AE	0.188	0.193		.189				
AF	0.125	0.160		.136				
AG	0.140	0.160		.145				
AH	1.360	1.400		1.373				
AI	0.040	0.060		.053				
AJ	1.190	1.230		1.214				
AK	0.010	0.020		.010				
AL	0.053	0.073		.063				
AM	0.240	0.260		.250				
AN	2.518	2.538		2.532				
AO	84.39	90.39		87.39				
AP	0.261	0.266		.262				
AQ	0.053	0.073		.063				
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 14 9-89	Date: 16/12/20
Audited by:	33 9-89	Date: 17/01/04
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
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8 7 6 5 4 3 2 1



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154153 MJS
16-12-07

- NOTES:**
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 (REF XXXX = ±0.010) UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
 - 7) WEIGHT: 0.78 lb
 - 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2893-1 SUPPORT

RELEASED
2011-07-28

C	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2893	REV. C SHEET 1 OF 1
TITLE Ø2.750 SUPPORT	SCALE NTS
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